

Work Order ID 77437-2

December-07-11 7:45:11 AM

77437

Page 1

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

Required Date: 21/12/2011 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: M L 15

Date: 11/12/11 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev:

Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Work Order ID 77437

77437

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Item ID: D4095-043
Revision ID:
Item Name: Wearplate Assembly

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Start Date: 07/12/2011 Start Qty: 6.00
Required Date: 21/12/2011 Req'd Qty: 6.00

6
6

Cust Item ID:
Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00 0.00				(8)			
140 *140* QC Quality Control	QC 5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.00				(X30)			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: M1200165 Large Fab Memo	0.00 0.00							

SB 11/12/13

SB 11/12/13

X4 12-01-18 JBL

Work Order ID 77437

77437

Page 3

December-07-11 7:45:11 AM

Item ID: D4095-043

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC 10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Sizkalis

Quality Control

170

QC 5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Sizkalis

(x4)

Quality Control

180

0.00

180

Hand Finish

Memo

0.00

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG

A/R ROCKGUARD BATCH 119947

Hand Finishing

1A 12-01-17

(4)

Work Order ID 77437

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77437

Page 4

Item ID: D4095-043
Revision ID:
Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00 *6*
Required Date: 21/12/2011 Req'd Qty: 6.00 *6*

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N):

N900040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		5126118		(4)			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-2</u> Memo	0.00 0.00							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

x4 & all 12/01/19
counted & measured

12/11/20

p.c.5 12/01/20
(4)

Picklist Print

December-07-11 7:45:17 AM

Page 1

Work Order ID: 77437

77437

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 07/12/2011

Required Date: 21/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

237.6000

2.275

14.36842

**

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

237.6

119653

237.6

DART AEROSPACE LTD		Work Order: 77437
Description: Wearplate		Part Number: D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1

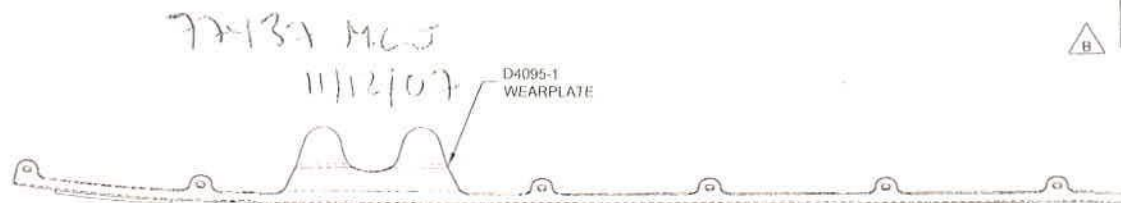
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.19	✓		✓	
0.300	+/-0.010	0.30	✓		✓	
0.300	+/-0.010	0.303	✓		✓	
2.432	+/-0.010	2.434	✓		✓	
3.227	+/-0.010	3.227	✓		✓	
4.06	+/-0.030	4.053	✓		✓	
2.50	+/-0.030	2.500	✓		✓	
4.98	+/-0.030	4.984	✓		✓	
8.43	+/-0.030	8.430	✓		✓	
11.50	+/-0.030	11.50	✓		✓	
21.750	+/-0.010	21.750	✓		✓	
3.500	+/-0.010	3.500	✓		✓	
12.22	+/-0.030	12.22	✓		✓	
6.000	+/-0.010	6.000	✓		✓	
12.100	+/-0.010	12.10	✓		✓	
21.00	+/-0.030	21.00	✓		✓	
30.000	+/-0.010	30.000	✓		✓	
36.000	+/-0.010	36.00	✓		✓	
38.88	+/-0.030	38.88	✓		✓	
0.063	+/-0.010	0.063	✓		✓	

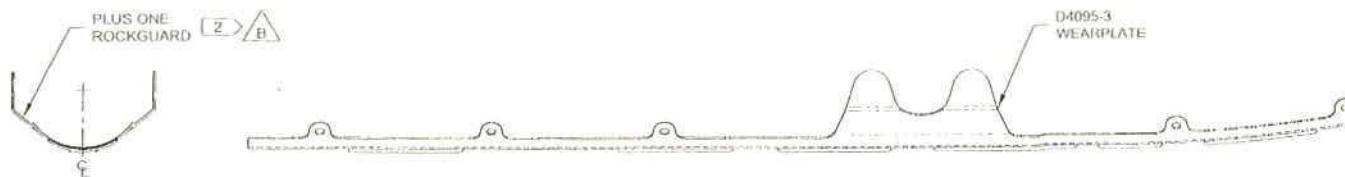
Measured by: B	Audited by: B	Preliminary Approval:
Date: 11-12-8	Date: 11/12/09	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	140		
MFG APPR.	140		
APPROVED	140		
DE APPR.	140		
DATE	11.10.18		

DART AEROSPACE USA, INC
KENT, WA

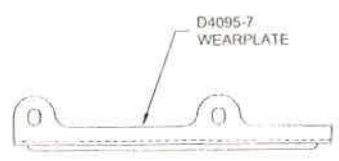
DRAWING NO
D4095

TITLE
WEARPLATE

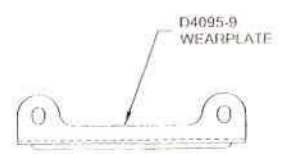
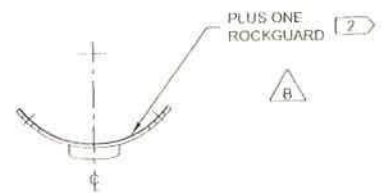
REV. B
SHEET 1 OF 8
SCALE
NTS

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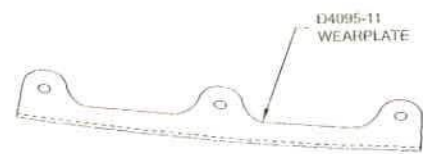
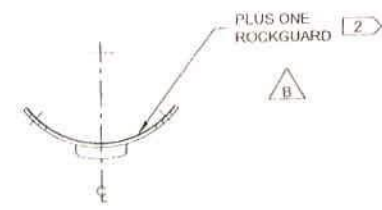
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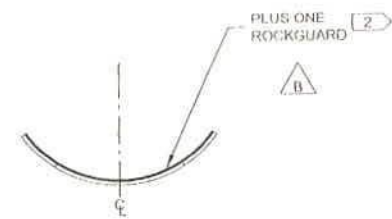
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



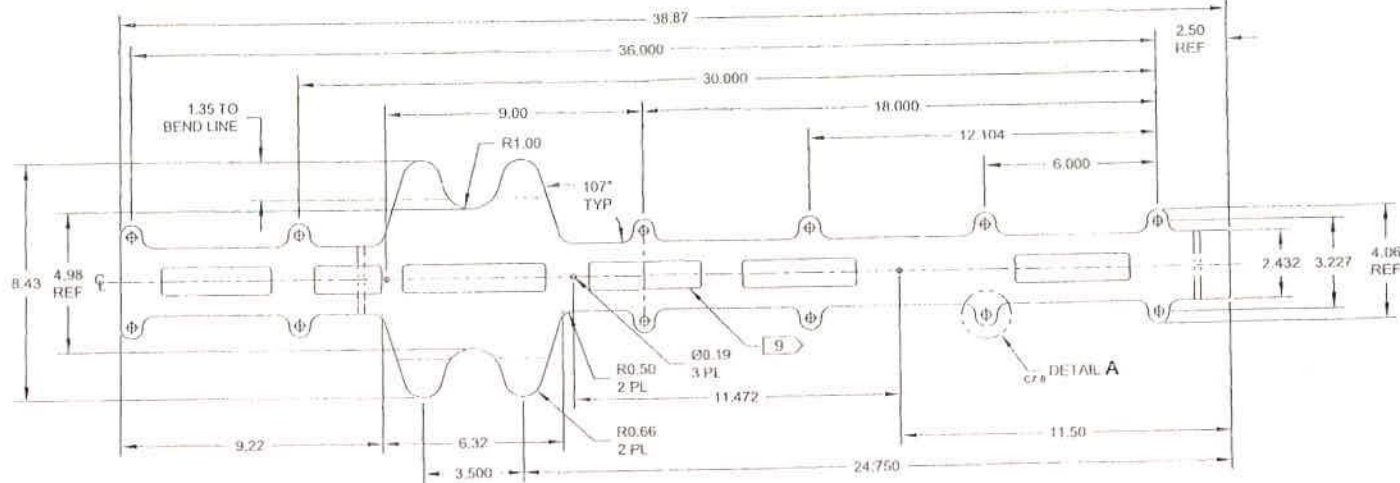
D4095-051 WEARPAD ASSEMBLY



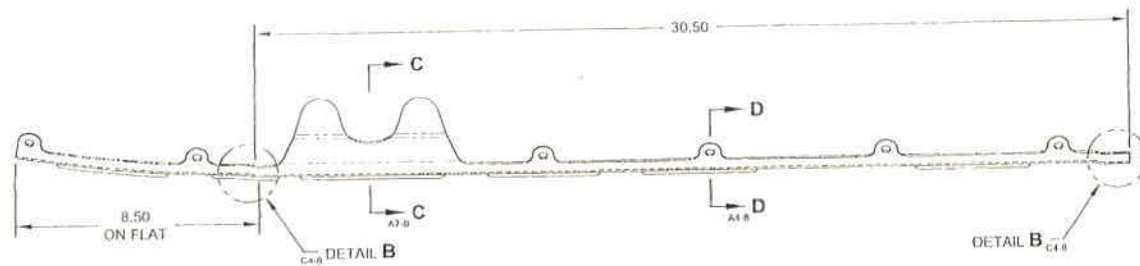
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2011-10-31

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MFG. APPR	140	D4095	SHEET 2 OF 8
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22431



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

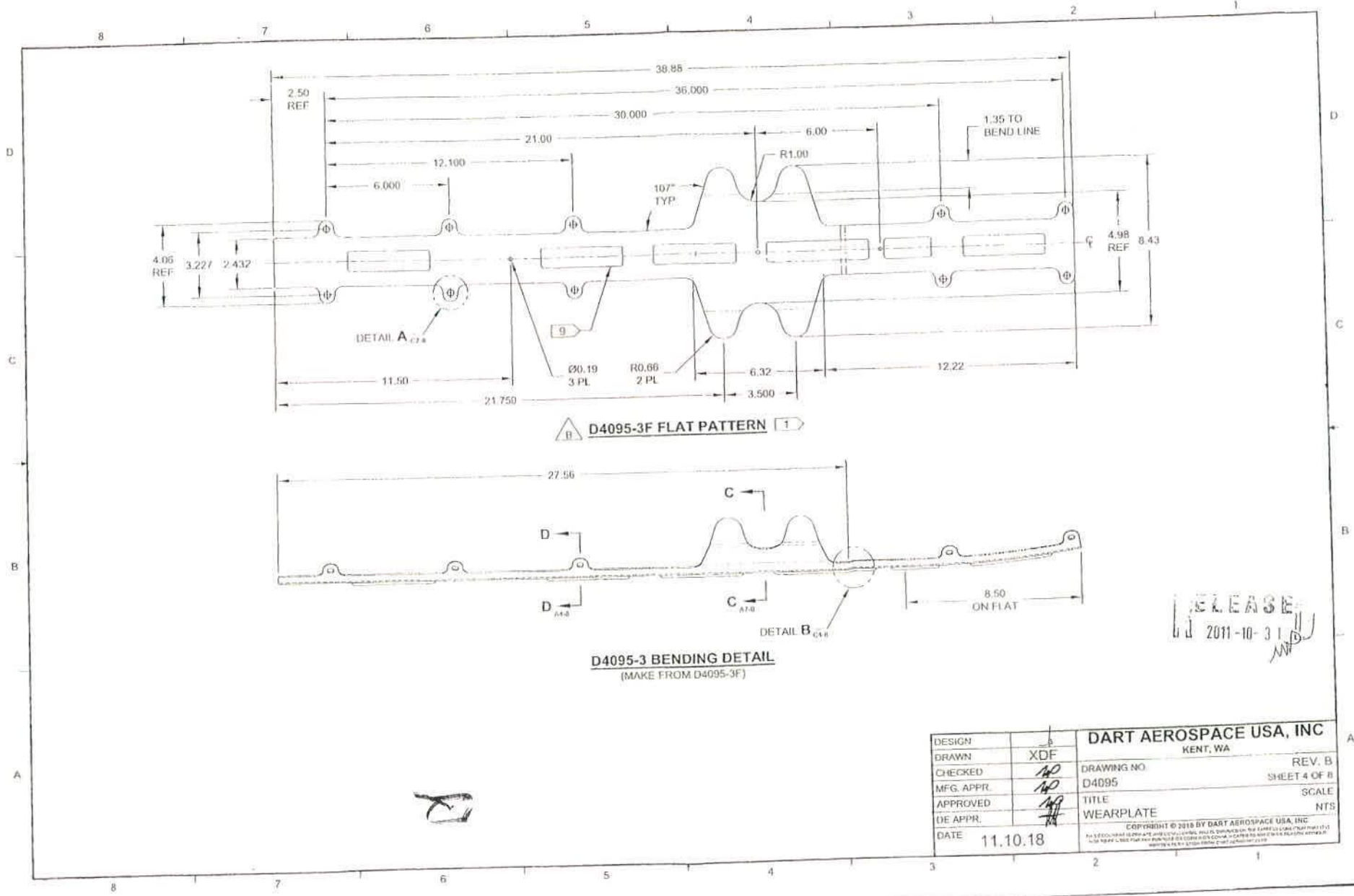
D4095-1F/3F/5F/7F/9F/11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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7743-1



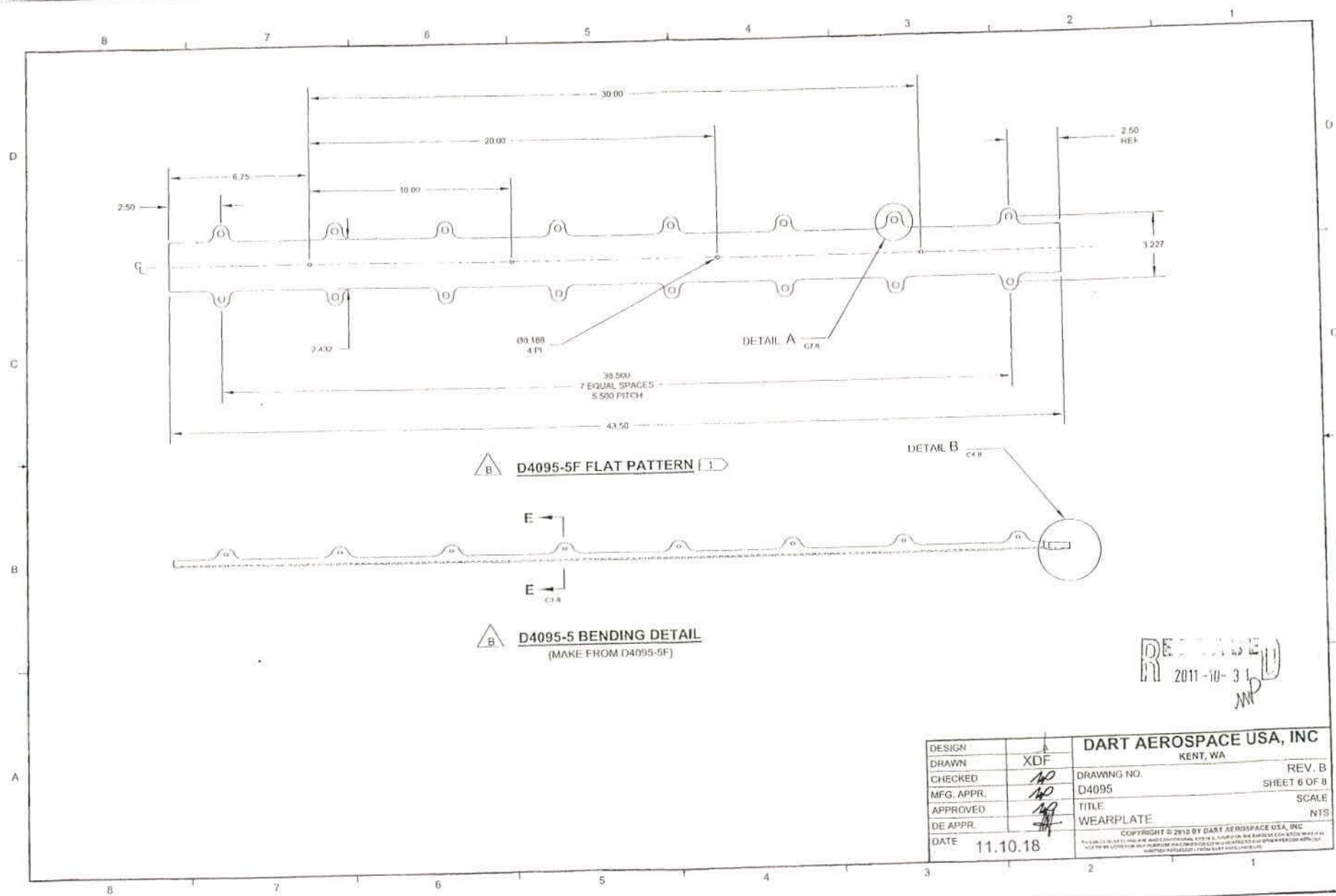
D4095-1 WELDING DETAIL

D4095-3 WELDING DETAIL

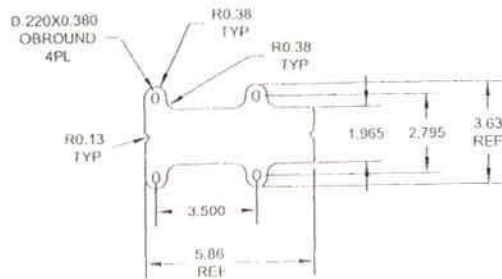
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2011-10-31
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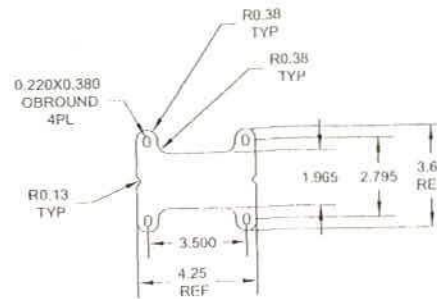
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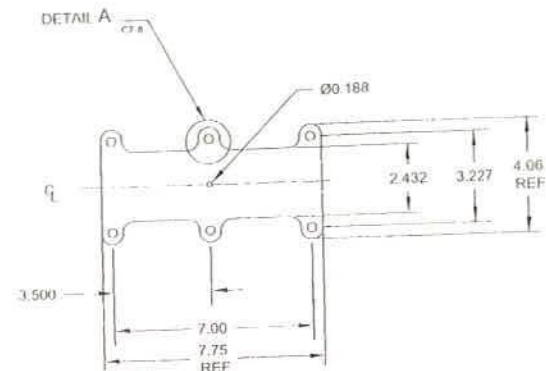
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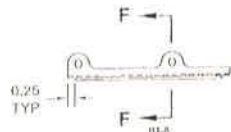
D4095-7F FLAT PATTERN



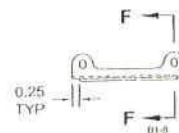
D4095-9F FLAT PATTERN



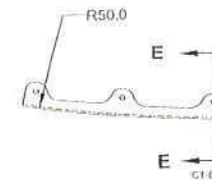
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)

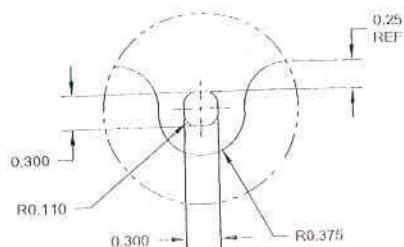


D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

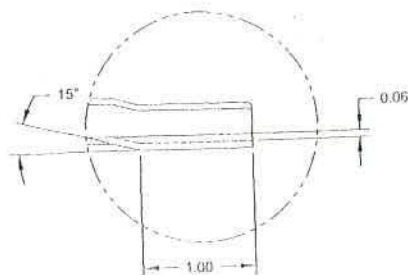
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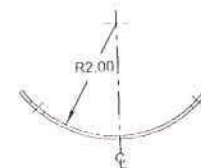
DETAIL A: TAB DETAIL

SCALE 4X
03-3
05-4
03-6
02-7



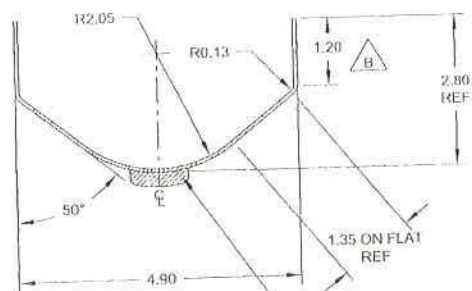
DETAIL B: JOGGLE DETAIL

SCALE 4X
02-3
03-3
03-4
02-6



SECTION E-E
SCALE 2X

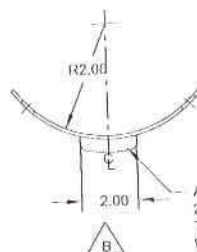
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2011-10-31
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SECTION C-C

SCALE 2X

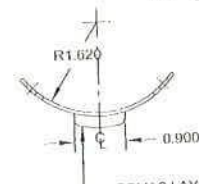
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION I-F

SCALE 2X

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DART AEROSPACE USA, INC			
DESIGN	XDF	KENT, WA	REV. B
DRAWN		DRAWING NO.	SHEET 8 OF 8
CHECKED		D4095	SCALE
MFG. APPR.		TITLE	NTS
APPROVED		WEARPLATE	
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